

Tuesday, September 22, 2009 12:27:15 PM

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Date:

Date:

Run Start

Stop

**Insp.
Stamp**

Revision Nbr

Rev A

100

0.00

[illegible]

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

Abstract

QC

Memo

0.00

Quality Control

Work Order ID 52358

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Page 2

Item ID: D3293-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1 - Deburr	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

Work Order ID 52358

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Item ID:	D3293-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Doubler					
Start Date:	9/23/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	10/9/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 9:10AM 9:40AM FINISH TIME: 3:20PM	0.00 0.00	=> Jd 09/10/15			XB	Ø		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	Jd 09-10-15			Ø			
180 Packaging Packaging	Identify as per dwg & Stock Location: 211 Memo	0.00 0.00	9/10/15				Ø	SJ	

Work Order ID 52358

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Page 4

Item ID: D3293-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 *[Signature]**MF*
09-10-16

Picklist Print

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Page 1

Work Order ID: 52358



Parent Item: D3293-1RevA



Parent Item Name: Doubler

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	184.6420	7.6901	15.3862		



2024-T3 .080 sheet



13 9-10-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	184.64205	
104921	3	
105411	17	
107460	4.36	
110908	29.52205	
112331	121.26	112331
15628	6	
17695	1.5	
18481	2	

DART AEROSPACE LTD		Work Order:	52358
Description: Doubler		Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	.353	X			
0.650	+/-0.010	.659	X			
1.874	+/-0.010	1.884	X			
Ø0.141	+0.005/-0.001	.142	X			
Ø0.128	+0.005/-0.001	.132	X			
17.750	+/-0.010	17.750	X			
20.15	+/-0.030	20.15	X			
R0.350	+/-0.010	.350	X			
R0.312	+/-0.010	.312	X			
0.080	+/-0.010	.080	X			

Measured by: IR	Audited by: S	Prototype Approval:	N/A
Date: 9-10-14	Date: 08/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	



UNCONTROLLED COPY
SUBJECT TO AMENDMENT

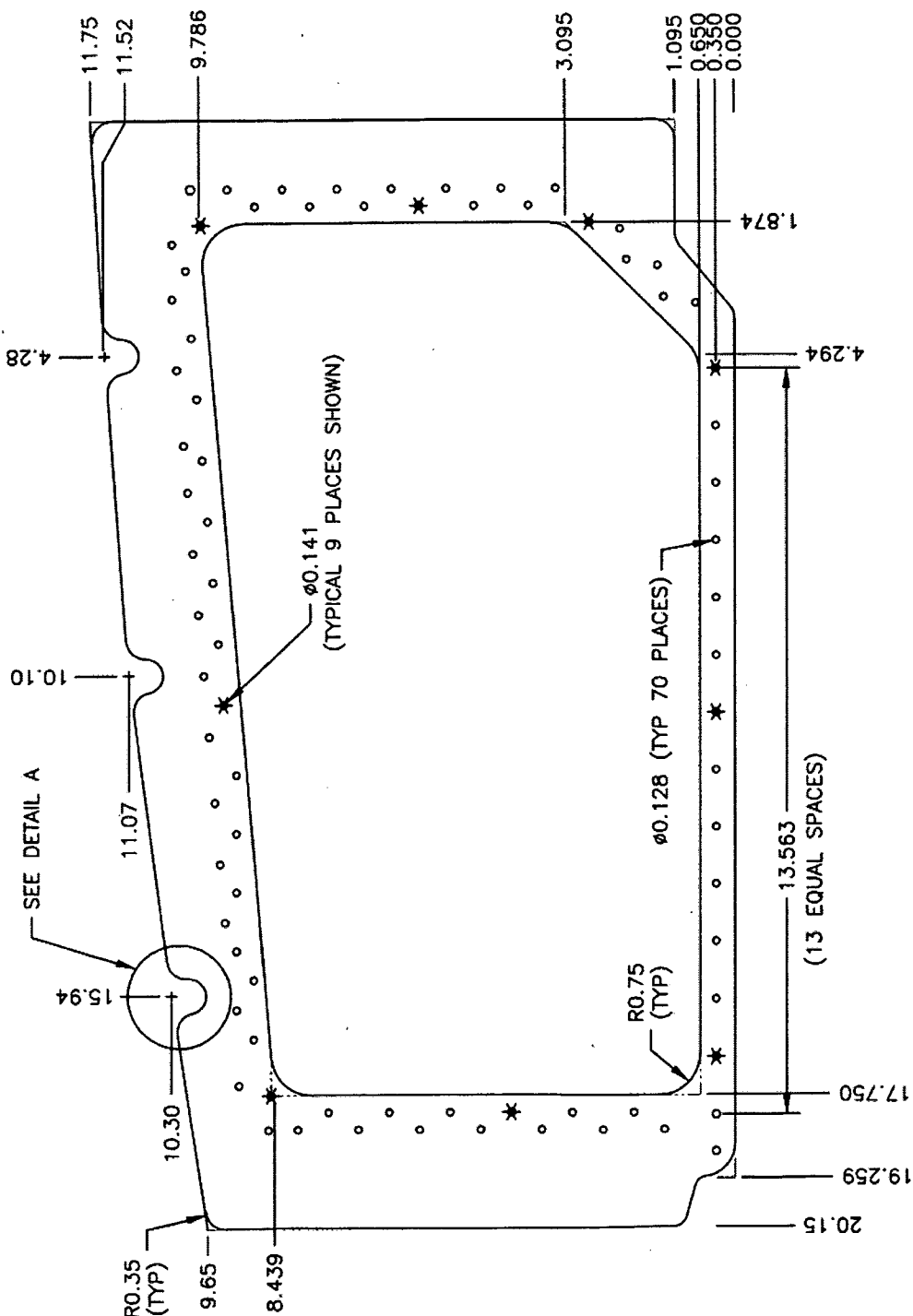
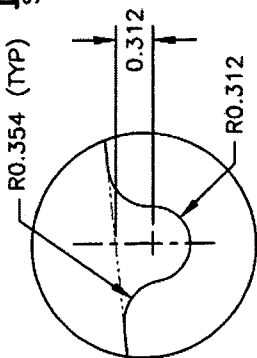
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3293	REV. A SHEET 1 OF 1
DATE 04.06.28		TITLE DOUBLER	SCALE 1:3
A	04.06.28	NEW ISSUE	

WITHOUT NOTICE
WORK ORDER
NO. 52358

D3293-1 DOUBLER
MAKE PER DRAWING FILE "D3293-A1.DWG"
CHECK PER TEMPLATE D3293-1T1
DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DETAIL A
SCALE 2:3



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